0.00

Memo

JM13-666

120

Quality Control

QC

NCR:	Yes	1	No
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Date: ___

DQA:

NCR: Ye	es / No				WORK ORDER NON-	CONFC)RN	MANCE / UPDATE	Q	A Closed:	Dat	te:	*	
Work Orde	. .				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Part No. Rework Scrap				Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.			Engineering Quality			
NCR N	o				Use-as-is Work Order Update	Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier			_	Other				
Root				Descri	ption of work order update	Initia	al	Action		Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chief (ng	Description		Date	Verification	n	QC Inspector	
Ooc/Data quip/Tooling Operator														
Material		ļ												
Setup]									ł		
Other						*						İ		
Process		1												
Supplier		1				:								
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Landin	g Gear				General			1	_		,			
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	Centre N	ot Conce	ntric to	o/s	BOM/Route	Har	dwa	e	∐o,	er/Under	tolerance	T	emperature/Cure	
	Cracks				Broken/Damaged	Insp	pectio	on Incomplete	Pa	rt Incorrec	t	\vdash	Veld	
	Crushed/	Crimped			Burrs	Inst	ructi	ons Incomplete/Unclear	Pa	rt Lost/Mi	ssing	\^	Vrong Stock Pulled	
	Cuffs				Contamination	Ma	inte	nance	Pa	rt Moved				
	Heat Trea	at			Countersink	Mis	labe	led	Po	sitioned V	/rong		i	
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read		Po	wer Loss/	Surge		Other	
	Ripples in	n Bend			Drill Holes	Off	set							
	Torque V	Vaves in I	Extrusio	n [Drawing	. Out	of C	alibration						
	Turning S	Sequence	!		Finish	Out	t of S	equence						
Ī	Wave/Tv	vist in Tui	he		Folio	□ Out	tside	Dimensions						

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Work Order May-27-13 12:40		2163	•	*102	2163*				Page 2	
Revision ID: Item Name: S	646.3715 Strut Doubler 6/27/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900040 Cust Item ID: Customer:	0100*	Setup	Start Stop	14.21	
Approvals:	Process Pla	n:	Date:		Date:		Run	Start Stop	"NRT"	
Sequence ID/ Work Center ID 130 *120* QC Quality Centrol		Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00 0.00	Tool ID Tool		ccept Re ty Qt		Reject Insp. Number Stamp	
140 *11111111111111		Outsource process-Anodi	ze per QSI017 4.1.10.1	0.00			<i>L</i>	1/13	-Clo-6	

150

Receive & Inspect for Damage & Mat'l Certs

Memo

Issue P/O to ATG: <u>AU//3</u>

1- Black Anodize as per Dwg 646.37002- PRIME AS PER DWG, SEE NOTE #2Certification of Comformity is required

0.00

150 Packaging

Outsource process - Anodize

Kaging

0.00

Packaging

[-73/4/12 (0)

NCR: Y	es / I	10				WORK ORDER NON-	CON	NFORM	MANCE / UPE	DATE	QA Closed:	Date	ع:
Work Orde	ŕ:					DISPOSITION				AGAINST DE			
Part N	o			<u>,</u>		Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o					Work Order Update	1		Large Fab	Composite	1 1100	Supplier	
Root					Descr	ription of work order update		nitial	Act	ion	Sign &		
Cause	Da	te	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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quip/Tooling			ł										
perator													
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rocess							1						
upplier		1					ł						
raining					i								
Inapproved													
			•			F	AUL	T CATE	GORY				
Landir	g Gear				_	General		•			_	_	
	Bend	ing				Bend		Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	Cent	re Not	Concen	tric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	(S				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	it _	Weld
	Crus	ned/Cri	imped			Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
	Heat	Treat			Γ	Countersink		Mislabe	led		Positioned V	Vrong _	<u> </u>
	Insp	ection S	Strip in	Tube		Cut Too Short		Misread	ſ		Power Loss/	Surge	Other
	Ripp	es in B	end			Drill Holes		Offset					
	Torq	ue Wa	ves in E	xtrusio	n	Drawing		Out of 0	Calibration				
	— 1 '		quence		r	Finish		Out of S	Sequence				
		_	t in Tub	e		Folio		Outside	Dimensions				

DQA:

Date:

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Work Ordo <i>May-27-13 12:4</i>		2163		*102	2163*					Page 3
tem ID: Revision ID: Item Name:	646.3715 Strut Doubler			Accept	*N9000	14010 0)* Seti	up Start Stop	*NS2	-
Start Date: Required Date: Reference:	5/27/13 5/27/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID Customer:): :				
Approvals:		an:		Tooling: SPC (Y/N):	Dat		Rur	Start Stop	*NR:	1* 2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours 0.00 Sト		Tool # Plan Code	_	•	Reject Ins Number Sta	sp. amp
190 *100* Packaging Packaging	. *	Memo	ock Location: \$753	0.00	HE P# AND] [3/4]	/-3C	- U
200 *200 QC		QC21- Final Inspection	Work Order Release	0.00				13/0	1174	4

Quality Control

W1306.13

										DQA:	Date	:	
NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	MANCE / UPDATE				*	
										QA Closed:	Date	:	
Work Orde	- -				DISPOSITION			AGAINST	DEPARTMENT/PROCESS				
TO THE	' 				Rework	1		Skid-tube Crosstube			Water Jet	Engineering	
Part N	0.				Scrap	1		Machining Small Fab	—	Proc	d. Eng. Coor.	Quality	
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NCR N	o				Work Order Update			Large Fab Composite			Supplier]	
	≟- - -	T											
Root					ption of work order update		itial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Description		Date	Verification	QC Inspector	
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quip/Tooling	- '	Ì											
Operator													
Material						İ							
Setup Other	-												
Process	\dashv											ļ	
Supplier	┪												
raining													
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Landin	g Gear				General				_		_	_	
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1	Centre No	ot Conce	ntric to (o/s	BOM/Route	—	Hardwa		\vdash	Over/Under	 	Temperature/Cure	
	Cracks			<u> </u>	Broken/Damaged	-	•	on Incomplete	\vdash	Part Incorrec	├	Weld	
	Crushed/	Crimped		<u> </u>	Burrs	$\boldsymbol{\vdash}$		ions Incomplete/Unclear	-	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			<u> </u>	Contamination	-		enance	\vdash	Part Moved			
1	Heat Trea				Countersink	\vdash	Mislabe			Positioned W		ا ا	
1	Inspectio	•	Tube	<u> </u>	Cut Too Short	\vdash	Misread	1	∐ ^F	Power Loss/S	ourge	Other	
1	Ripples in			<u> </u>	Drill Holes	Offset							
1	Torque W			[¬]	Drawing	-		Calibration	_				
	Turning S			L	Finish	\vdash		Sequence	_				
ŀ	Wave/Tw	ist in Tul	pe e		Folio	Outside Dimensions							

Picklist Print

May-27-13 12:40:29 PM

Work Order ID:

102163

Parent Item:

646.3715

Parent Item Name:

Strut Doubler

Start Date: 5/27/13

Required Date: 5/27/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			110	sf	671.7156	0.0434	0.3654737			7mB-60-6
6061-T6 .040 Sheet											A. Patrician A	C	J 14110-60-1
				Location		Loc Qty	L	oc Code					
				MAT021		671 7156							

273.7156

398

121099

123874

NCR:	Yes	/	No

DQA: _____ Date: ____

NCR: Ye	es / No				WORK ORDER NON-	CONFO	RIVIAINCE / UP	DATE	QA Closed:	Date:	
Work Order					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
•	Rework Scrap				Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality		
NCR No	D				Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descr	iption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Desc	ription	Date	Verification	QC Inspector
oc/Data											
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Other	_										
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upplier	_										
raining	_										
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						FAULT CA	EGURT				
Landin _i	_			Г	General Bend	Grain			Ovalized		Pressure/Forced
}	Bending Centre No	at Canca	atric to (,, -	BOM/Route	Hard		 	Over/Under	tolerance	Temperature/Cure
-	Cracks	or concer	iti ic to t) ³ -	Broken/Damaged	·····	ction Incomplete	<u> </u>	Part Incorre	-	Weld
<u> </u>	Crushed/	Crimpad		-	Burrs	—	ections incomplete/	Linclear —	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
-	Cuffs	Crimpeu		-	Contamination	$\boldsymbol{\boxminus}$	itenance	-	Part Moved		7 8
F	Heat Trea	at		<u> </u>	Countersink	Misla			Positioned V	Vrong	1
<u> </u>	Inspectio		Tube	 	Cut Too Short	Misre		-	Power Loss/		Other
 	Ripples in				Drill Holes	Offse			」	<u> </u>	1
+	Torque V		xtrusio	,一	Drawing	—	f Calibration			· · · · · · · · · · · · · · · · · · ·	· · ·
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<u> </u>	Wave/Tw	•			Folio	\vdash	de Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

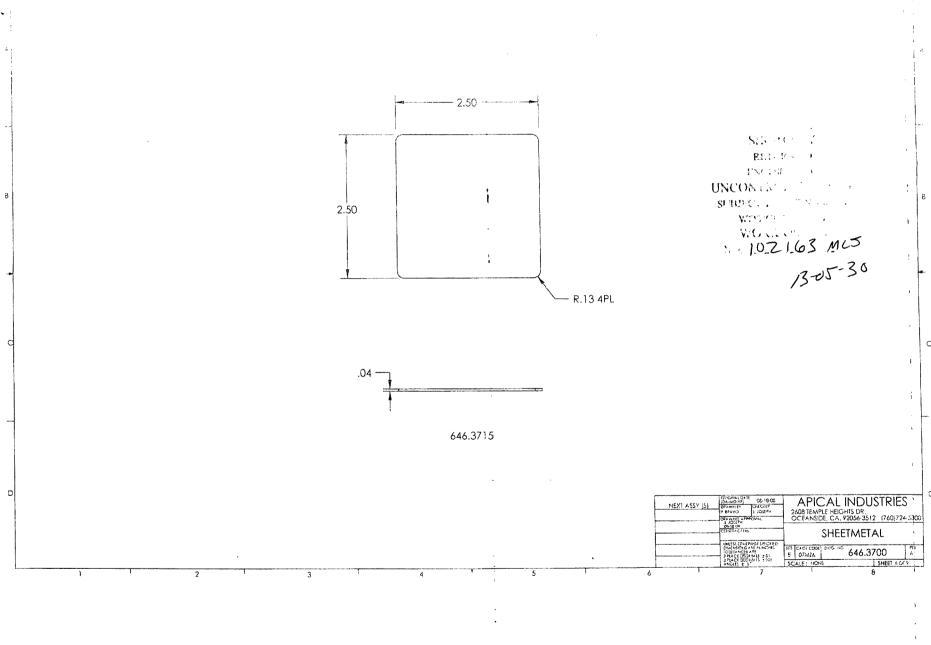
DART AEROSPACE LTD	Work Order:	102/63
Description: Strut Doubler	Part Number:	646.3715
Inspection Dwg: 646.3700 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.005	2.503"	_		V	Skmoi
2.50	+/-0.005	2.504"	_		U	
0.040	+/-0.005	2.503"	-		V	
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	V. Z i	
Measured by: 5m	Audited by:	Preliminary Approval:
Date: (3-6-6	Date: 13-6-6	Date:

Rev	Date	Change	Revised by	
Α	13.03.04	New Issue	KJ 📥	X M
L	L			1





A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62441

Date: 12-Jun-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

	200 Fax: 613-632-1185		Ph: 613-632-5200	Fax: 613-632-1185		
ıs		Ship Via				
uantity	Description					
/10 ea	Part: 646.3311		Rev:	······································		
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2					
	PRIME MIL-P-23377J TYPE I CLASS N					
	Job: 20130360	PO: 19997	Line:	•		
10 lot	Part: 646.3210		Rev:			
Ю	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2					
	PRIMER PER MIL-P-23377J TYPE	I CLASS N				
	Job: 20130359	PO: 20099	Line:			
	Part: ASST		Rev:			
lot /	10 PCS 646.3715 12 PCS 646.3812					
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2					
	PRIME MIL-P-23377J TYPE I CLA	SS N				
	Job: 20130358	PO: 20113	Line:			
				•		
	Certificate of Co	nformance		4.		



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62441

Date: 12-Jun-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 612 622 5200

		-	FII. 613-632-5200	Fax: 613-632-1185	
Terms		Ship Via			
Quantity	Description				
Quantity	A.T.G. Industries certifies that all item with all requirements, specifications at ISO 9001 : 2008 RI ATG SALES-2010 TO SALES SIGNATURE : RECEIVER SIGNATURE :	nd drawings reference EGISTERED TERMS APPLY	ed in the purchase order.		